

*SPLIT*

Wednesday, 25/07/2007 8:32:28 AM  
Linda Laidie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 33729		
Estimate Number	: 11047 -1		
P.O. Number	: <i>N/A</i>	Part Number	: D28441
Issue	: 25/07/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2844 REV A
Issue Rev.	: NC	Project Number	: N/A
Issue	: <i>N/A</i> Type : SMALL/MED FAB	Drawing Revision	: A
Previous Run	: 32284	Material	: <i>N/A</i>
Drawn By	: <i>[Signature]</i>	Due Date	: 24/08/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	12 Um: Each
Comment	: Est: B 00.11.01 Removed P/O for Powder Coat - in house process EC		

Additional Product



Seq #:	Machine Or Operation:	Description :
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1.0	M304TRO500W035	304 RD Tube .500 x .035W
Comment: Qty: 1.9941 f(s)/Unit Total: 23.9287 f(s) 304 RD Tube .500 x .035W M304TRO500W035 Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 21.49" long (Hole ctr. to hole ctr.) using Jig DT 8012 <i>M104862</i> <i>10</i> Batch <i>M104565</i> <i>3</i> <i>07-07-24</i>		

2.0	BRAKE NC	NC BRAKE
Comment: BAND SAW Form per Dwg D2844 using brake and bending Jig DT 8238-B Deburr <i>07-07-26</i> <i>13</i>		

3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <i>En 07/07/26</i> <i>10</i>		

4.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING <i>M105068</i> <i>BR/FL 07-07-26</i> <i>10</i> Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3		

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>07-07-26</i> <i>10</i>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070725	3.0	3 x D 2844-1's were missing using 0.049" wall instead of 0.035" wall.  R/L Employee pulled away from		Split w/o and continue but do not pass step # 60 (QC #6)				En 07/07/06

NOTE: Date & initial all entries

Date: Wednesday, 25/07/2007 8:32:28 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 33729

Part Number: D28441

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

ensure parts are still as per dwg D2844

Sw 07/07/26

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

CP 07/07/26 @10

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Sw 07/07/07

Job Completion:



POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

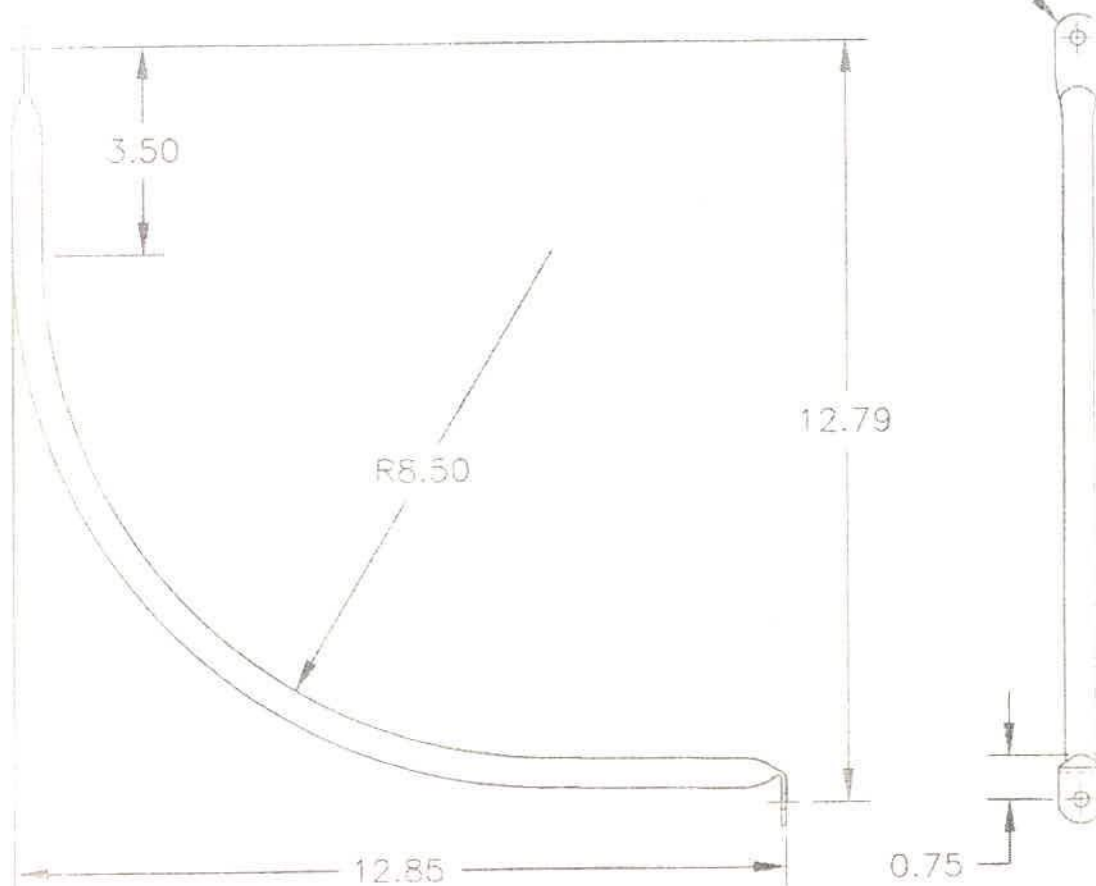
W 07/07/27



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>PAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED  
98.11.11 KE

RUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

MATERIAL: AISI 304/316 SS TUBE,  $\phi 0.50 \times 0.035$  WALL  
ENSURE TUBE IS SEAMLESS  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

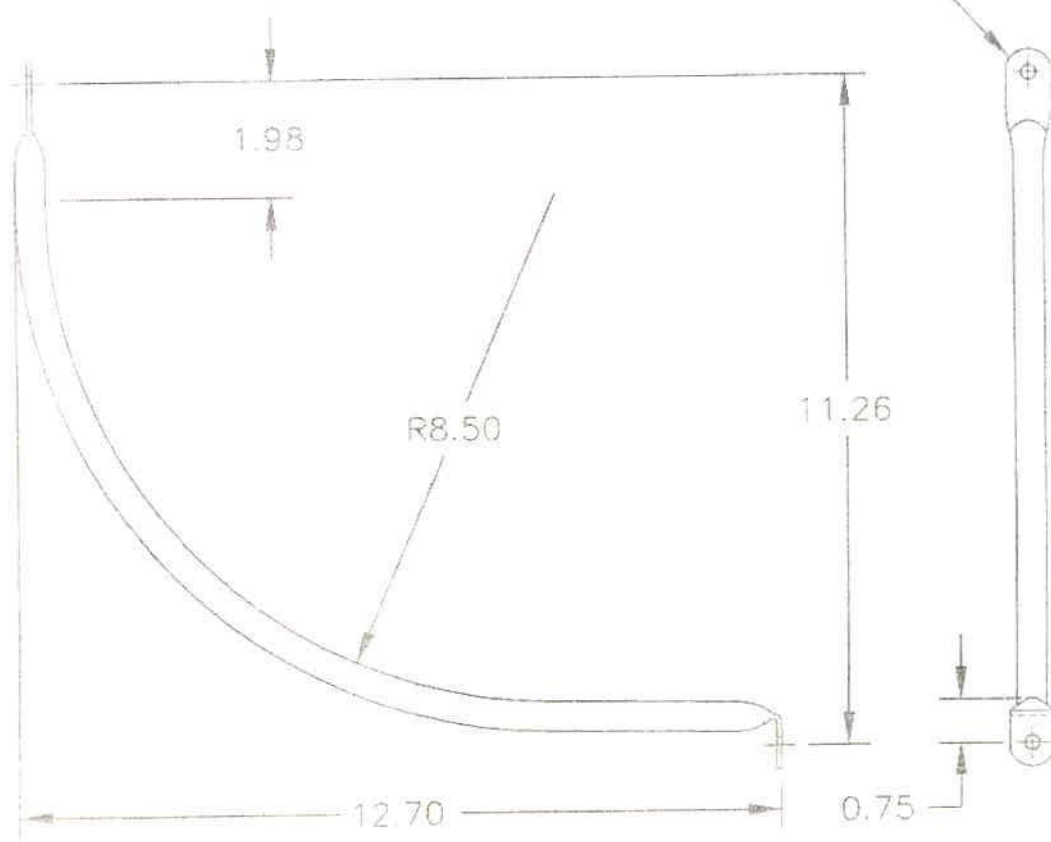




DESIGN KE	DRAWN BY KE	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED DAH	APPROVED [Signature]	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3

RELEASED  
19.11.11

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

MATERIAL: AISI 304/316 SS TUBE,  $\phi 0.50 \times 0.035$  WALL  
ENSURE TUBE IS SEAMLESS  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3